

Work Order ID 162770

Monday, June 12, 2017 12:43:41 PM

162770

Page 1

Item ID: D3947-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Panel , Lower LH Post (Sub-Comp D350-766-015)
 Start Date: 6/19/2017 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 6/27/2017 Req'd Qty: 3.00 *3* Customer:
 Reference: SCHEDULED/C

Approvals: Process Plan:  Date: JUN 12 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3947	A

110 THERMOFORMING MACHINE 0.00

110

Purchasing

Purchasing

Memo

ISSUE P/O:

SUPPLIER: PLASTECB

MANUFACTURE D3947-3 AS PER DWG

C OF C IS REQUIRED

36858

4 3

JUN 28 2017

DAS
13
9-89

140 Receive & Inspect for Damage & Mat'l Certs 0.00

140

Packaging

Packaging

HAND FINISHING THERMOFORMING

Memo

4 3x SP 17-7-10

*145
SMALL FAB

TRIM TO DWG.

DAS
07
9-89
17/07/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC6- All purchased or subcontracted products Memo	0.00 0.00				4			DAS 07 9-89 17/07/11 17/07/11 JUL 20 2017
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>St 427</u> Memo	0.00 0.00				6			DAS 06 9-89 JUL 11 2017 JUL 20 2017
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							17/7/2017

DAS
21
9-89

JUL 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
24- 240 24- TO 98-0									
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
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LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
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Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

Picklist Print

Monday, June 12, 2017 12:43:53 PM

Page 1

Work Order ID: 162770

162770

Parent Item: D3947-3

D3947-3

Parent Item Name: Panel , Lower LH Post (Sub-Comp D350-766-015)

Start Date: 6/19/2017

Required Date: 6/27/2017

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL
NOW OUTSIDE PROCESS DD VERF:DP

Ipp Rev B
IPP REV:C 17.06.12

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3947-3P		Purchased	No				Each	0.0000		3			
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D3947-3P

Panel , Lower LH Post (Sub-Comp D350-766-015)

**

3 x 8 17-7-10

DQA: _____ Date: _____

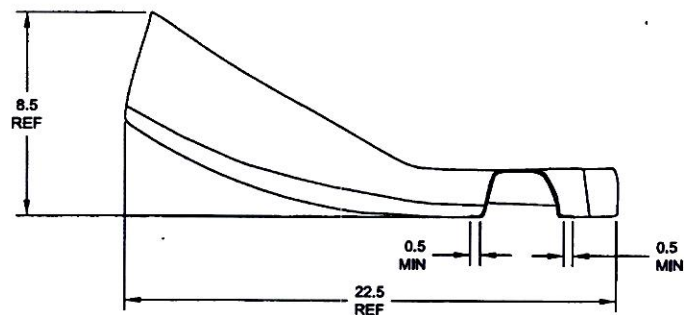
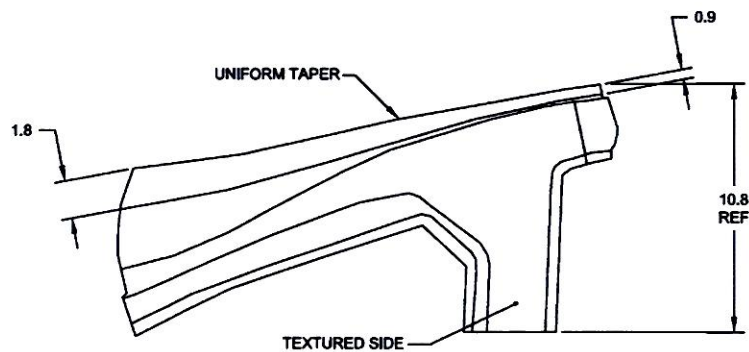


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

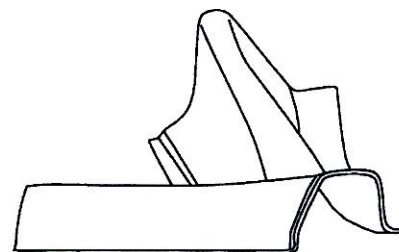
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Misidentified ☐	Past Due ☐																																																														



D3947-3 PANEL, LH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162770

JUN 12 2017



RELEASED
09/05/14

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-3" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.55 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9484 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE

DESIGN	90	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3947	SHEET 3 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	PANEL (AS 350/355)	NTS
DATE	09.05.20	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36858

Purchase Order Date 6/28/2017

PO Print Date 6/28/2017

Page Number 2 of 3

Order From :
PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 416-736-0004

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 60
Currency CAD
FOB Destination-Collect

3	D3947-3P	Panel , Lower LH Post (Sub-Comp D350-766-015)	7/5/2017	FN	3.00	\$85.00	\$255.00
			Yes		Each		
			7/5/2017				

AS PER DWG D3947 REV. A
B162770

SP7-7-10

Line Total: \$255.00

4	D3947-2P	Panel , Upper RH Post (Sub-Component D350-766-015)	7/5/2017	FN	3.00	\$85.00	\$255.00
			Yes		Each		
			7/5/2017				

AS PER DWG D3947 REV. A
B162769

QAS
38
9-89

Line Total: \$255.00

5	D3947-1P	Panel , Upper LH Post (Sub-Comp D350-766-015)	7/5/2017	FN	3.00	\$85.00	\$255.00
			Yes		Each		
			7/5/2017				

AS PER DFWG D3947 REV. A
B162768

Note:

6/28/2017

Ship Date: 07/06/2017

Pick Ticket - 23194

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: CHANTEL LAVOIE
O

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: CHANTEL LAVOIE
O Email: clavoie@dartaero.com
Tel: (613) 632-5200

Purchase Order	Sales Order	Incoterms	Payment Method
PO36858	SO-019079		COL
Carrier Account #	Ship Via	Tracking Number	
	FREIGHTCOM INC. -		
Payment Terms	Account Status		
NET 60	Active		

Item Number - Revision	Description	Quantity To Ship	UOM
CUSTOM -	SETS GREY POLYCARBONATE KIT Shipment Date: 7/6/2017 D3946 / D3947 SERIES HS Code: 8708.8.1000 - Country of Origin : CA	3 <u>3</u>	EA

1 PC D3946-1P
1 PC D3947-4P
1 PC D3947-3P
1 PC D3947-2P
1 PC D3947-1P

8017-710

DAS
38
9-89

Number of Containers	Gross Weight	Shipped By
		

DART AEROSPACE LTD		Work Order: 162770
Description: Panel, Lower LH		Part Number: D3947-3
Inspection Dwg: D3947	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>2 1/4"</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>DAS</u> 07 9-89	Date: 17/07/19
--	-----------------------

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5	Min	0.5"	✓			
1.8	Min	1.8"	✓			
0.050	Min	0.060"	✓			
0.065	Min	0.078"	✓			
22.5	REF	22.5"	✓			
10.8	REF	11.0"	✓			

Measured by: <u>DAS</u> 07 9-89	Date: 17/07/19
Audited by: <u>DAS</u> 38 9-89	Date: JUL 20 2017
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	